

Work Order ID 69634

Thursday, May 12, 2011 3:45:45 PM



ASAP

Page 1

Item ID: D3371-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Lock Cover

Start Date: 5/13/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 1-05-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3371

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.00" x 2.25" x 7.370" long

cut 11/05/18

4 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3371-3 as per Folio FA486 and Dwg D3371
2-Deburr
3-Finish 8-32 thread by hand
Identify as D3371-3

B.A 11/05/18

4 1

Pto ->

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A 11/05/18

4 0

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3371-3 PAR #: _____ Fault Category: Machining NCR: (Yes) No DQA: AK Date: 11-05-27
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CK Date: 11/05/27

| NCR: <u>369634</u> | | WORK ORDER NON-CONFORMANCE (NCR) # <u>130.89</u> | | | | | | |
|--------------------|--------------|---|----------------------------------|---|-------------------------------|-------------------------------|----------------------------------|-----------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| <u>11/05/19</u> | <u># 110</u> | <u>Dim. 1.330 ± .005 is measured</u> <u>1.304/1.300 (.025/0.004)</u> <u>R.C. Part 1.4 to during machine</u> <u>Process</u> | <u>11-05-19</u> <u>OS1042</u> | <u>→ SCRAP + REPLACE.</u> <u>B: 112764</u> | <u>B.A</u> <u>11/05/19</u> | <u>enf</u> <u>11/05/19</u> | <u>11-05-19</u> <u>OS1042</u> | <u>S</u> <u>11/05/19</u> |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 69634

Thursday, May 12, 2011 3:45:46 PM

Page 2

Item ID: D3371-3

Accept

Revision ID:

Item Name: Pedal Lock Cover

Start Date: 5/13/2011 Start Qty: 4.00

Required Date: 5/20/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

mk 11/05/19

4

9

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4

6

all 11/05/19

145

Fire Red(Ref:4.3.5.10) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

cover inside holes prior painting

Start Time:

Oven Temperature:

Finish Time:

7230
320 OF
8715

4X 8 m/f 11/05/20

M102391

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 69634

Thursday, May 12, 2011 3:45:46 PM



Page 3

Item ID: D3371-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Lock Cover

Start Date: 5/13/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 6 21 11/05/20

160

Identify as per dwg & Stock Location: CA

0.00



Packaging

Memo

0.00

Packaging

SP 11/05/24



170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/24

mf

11-05-24

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Thursday, May 12, 2011 3:45:39 PM

Page 1

Work Order ID: 69634

Parent Item: D3371-3

Parent Item Name: Pedal Lock Cover



Start Date: 5/13/2011

Required Date: 5/20/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 05.01.18 New issue KJ/JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B2.000X02.25 0 | | Purchased | No | | | 100 | f | 0.0000 | 0.625 | 2.631579 | | | |



6061-T6 Bar 2.00 x 2.25



6061-T6 2.00" x 3.500" M112764 x 4 = 2.6316
auth 11/05/18

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

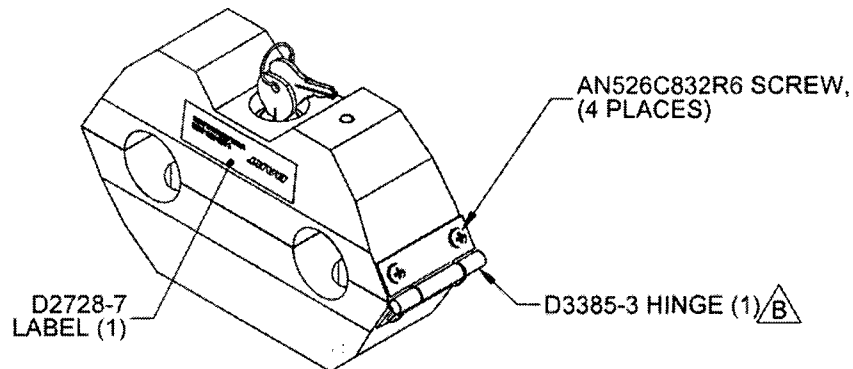
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
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NOTE: Date & initial all entries

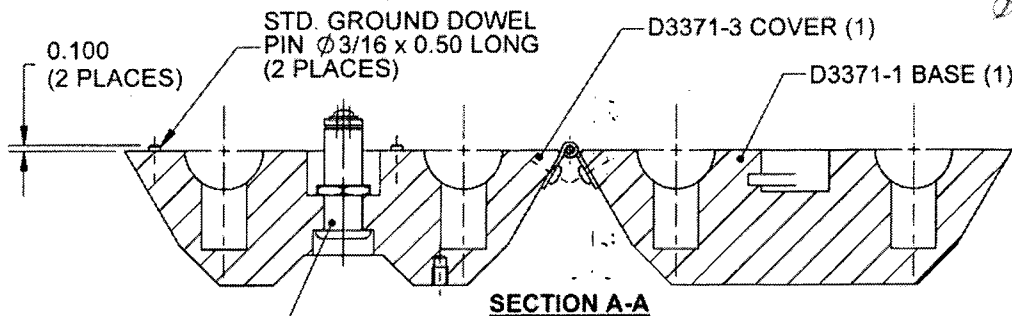


| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN [Signature] | DRAWN BY [Signature] | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3371 | REV. B SHEET 1 OF 4 |
| DATE 05.03.22 | | TITLE PEDAL LOCK | SCALE 1:3 |
| A | 04.12.06 | NEW ISSUE | |
| B | 05.03.22 | D3385-3 WAS D3385-1 | |

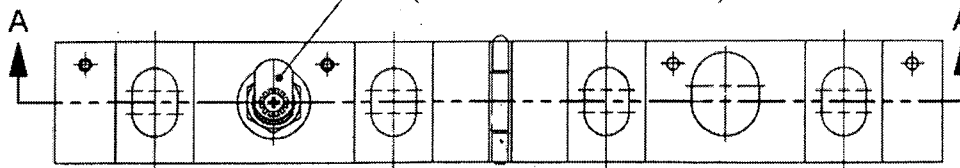


PEDAL LOCK SHOWN LOCKED WITH KEY

RELEASED
[Signature]
05/04/28



D3371-5 CAM (1),
AND SQUARE WASHER SPACER (1),
EXTERNAL TOOTH LOCK WASHER (1),
#10-32 UNF PAN CROSS HEAD SCREW (1)
(AS PER D3373 DRAWING)



D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

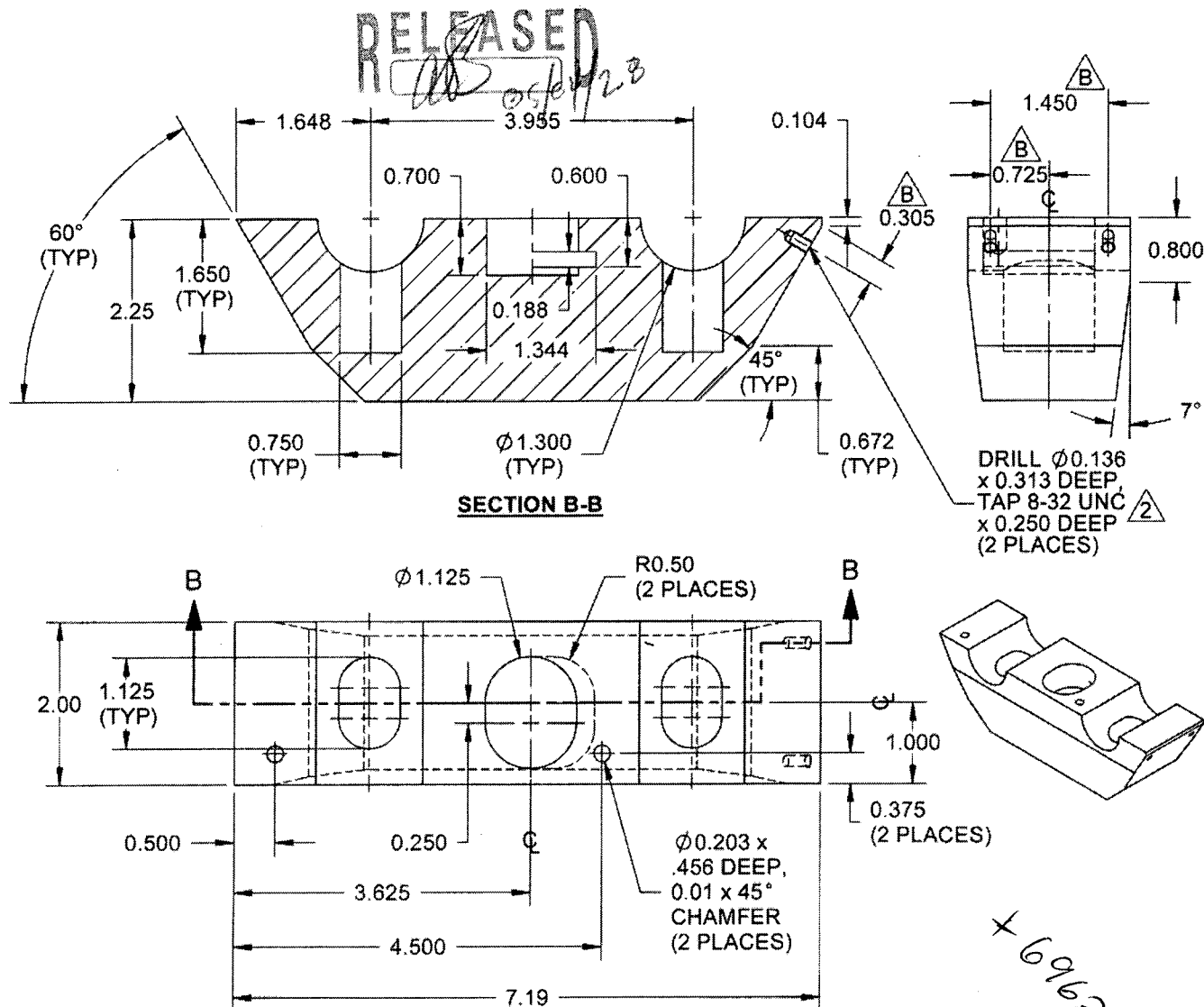
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



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|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3371 | REV. B SHEET 2 OF 4 |
| DATE 05.03.22 | TITLE PEDAL LOCK | SCALE 1:2 | |



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

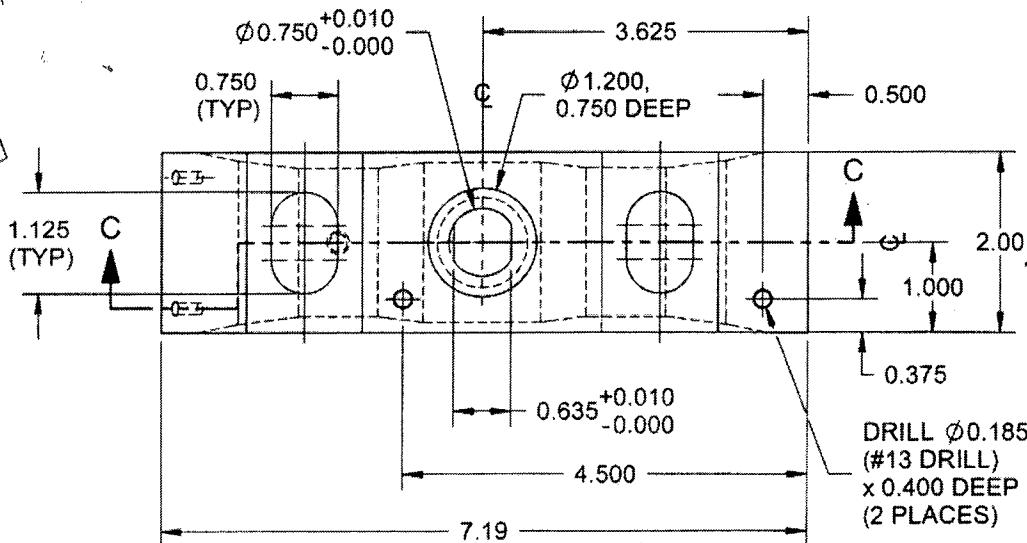
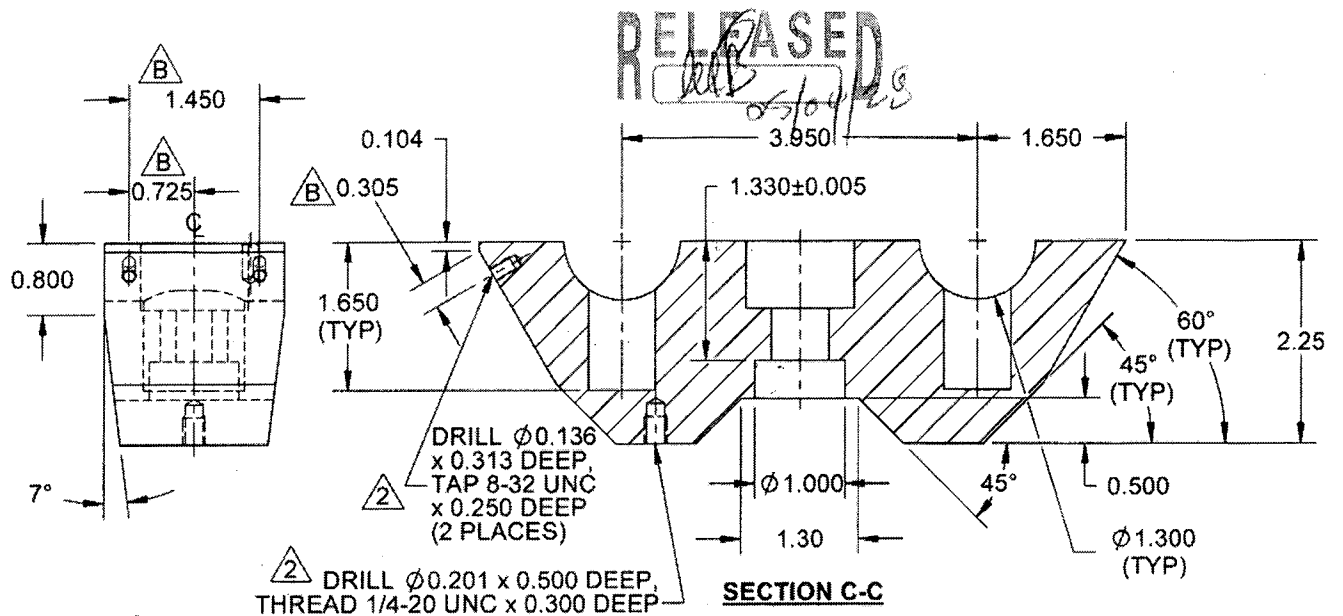
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3371 | REV. B SHEET 3 OF 4 |
| DATE 05.03.22 | TITLE PEDAL LOCK | SCALE 1:2 | |



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
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POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
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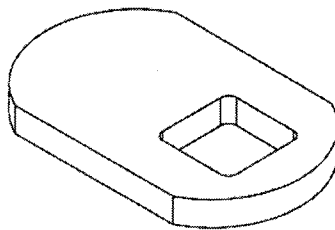
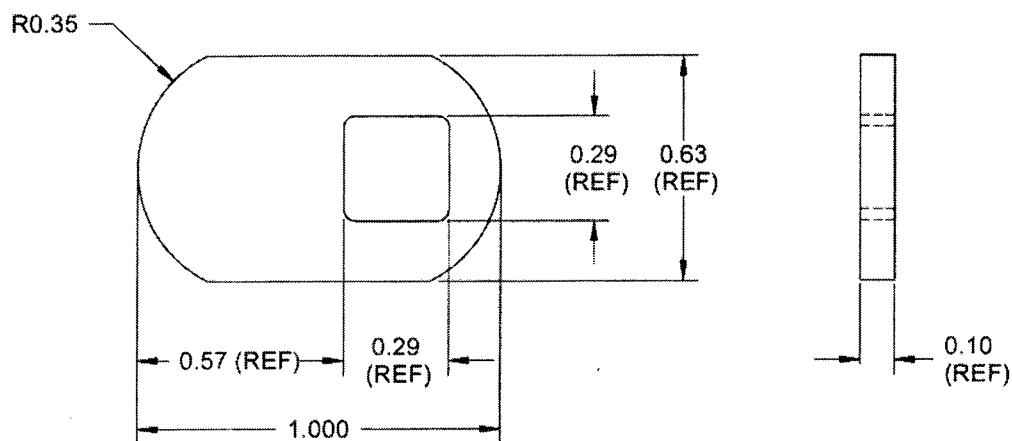
NOTE: Date & initial all entries



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|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN/BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3371 | REV. B SHEET 4 OF 4 |
| DATE 05.03.22 | TITLE PEDAL LOCK | | SCALE 2:1 |

RELEASED
[Signature]
05/04/22

SPECIFICATION CONTROL DRAWING



#69634

D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

| | | |
|--------------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 69634 |
| Description: Pedal Lock Cover | | Part Number: D3371-3 |
| Inspection Dwg: D3371 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 1.450 | +/-0.005 | 1.450 | ✓ | | Vern | GA-01 |
| 7° | +/-0.5° | 7° | ✓ | | Angle Meter | CNC-08 |
| 0.104 | +/-0.010 | 0.105 | ✓ | | Vern | GA-01 |
| 0.305 | +/-0.010 | 0.312 | ✓ | | " | " |
| 1.650 | +/-0.010 | 1.648 | ✓ | | " | " |
| 1.30 | +/-0.030 | 1.300 | ✓ | | " | " |
| Ø1.000 | +/-0.010 | Ø1.003 | ✓ | | " | " |
| 45° | +/-0.5° | 45° | ✓ | | Angle Meter | CNC-08 |
| Ø1.300 | +/-0.010 | Ø1.300 | ✓ | | Vern | GA-01 |
| 0.500 | +/-0.010 | 0.498 | ✓ | | " | " |
| 60° | +/-0.5° | 60° | ✓ | | Angle Meter | CNC-08 |
| 2.25 | +/-0.030 | 2.251 | ✓ | | Vern | GA-01 |
| 1.650 | +/-0.010 | 1.649 | ✓ | | D-6 | GA-08 |
| 3.950 | +/-0.010 | 3.950 | ✓ | | Vern | GA-01 |
| 1.330 | +/-0.005 | 1.330 | ✓ | | H-6 | 31006 |
| 7.19 | +/-0.030 | 7.188 | ✓ | | Vern | CNC-02 |
| 4.500 | +/-0.010 | 4.498 | ✓ | | Vern | GA-01 |
| 0.635 | +0.010/-0.000 | 0.635 | ✓ | | " | " |
| 1.125 | +/-0.010 | 1.125 | ✓ | | " | " |
| 0.750 | +/-0.010 | 0.751 | ✓ | | " | " |
| Ø0.750 | +0.010/-0.000 | Ø0.758 | ✓ | | " | " |
| 3.625 | +/-0.010 | 3.622 | ✓ | | " | " |
| Ø1.200 | +/-0.010 | Ø1.201 | ✓ | | " | " |
| 0.750 deep | +/-0.010 | 0.751 deep | ✓ | | " | " |
| 0.500 | +/-0.010 | 0.501 | ✓ | | " | " |
| 2.00 | +/-0.030 | 1.996 | ✓ | | " | " |
| 1.000 | +/-0.010 | 0.997 | ✓ | | " | " |
| 0.375 | +/-0.010 | 0.373 | ✓ | | " | " |
| Ø0.185 | +0.005/-0.000 | Ø0.188 | ✓ | | " | " |
| 0.400 deep | +/-0.010 | 0.401 deep | ✓ | | " | " |

| | | |
|--------------------------|--------------------------------|--------------------------------|
| Measured by: J.A. | Audited by: [Signature] | Prototype Approval: N/A |
| Date: 11/05/18 | Date: 11/05/19 | Date: N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--------------------|------------|-------------|
| A | 05.04.26 | New Issue | KJ/JLM | |
| B | 05.05.25 | Revised dimensions | KJ/JLM | [Signature] |

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries